

Work Order ID 164020

Tuesday, July 11, 2017 8:45:30 AM

164020

Page 1

Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Basket Base Assembly (350)
Start Date: 7/21/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/18/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: JUL 13 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4017	F								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 3136920 0.00***100***

Large Fab

Large Fab

Large Fab

Memo

2.77

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh

2- Cut mesh as per dwg D4020-3

3- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends

4- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

5- Weld D4672-3 blanking plates as per dwg

14 CC 17-8.9

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

AUG 09 2017 **DAS 24**
9-89

Page 2

Hand Finishing

23
17-08-1

1x d 12/08/17

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2--Mask this area prior to finish View G-G 1ST COAT: START TIME: 10:30am OVEN TEMPERATURE: 375°F FINISH TIME: 10:45am ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.52				1	1	1	17-08-17
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				1			17-08-17

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Assemble as per dwg Memo	0.00 0.63				1.0	0	22	6/28/17
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1			38 9-89 AUG 17 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/O</u> Memo	0.00 0.01			D4032-041 / D164019	1.0	0	22	6/28/17

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89

AUG 18 2017

Picklist Print

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Page 1

Work Order ID: 164020

164020

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM IPP Rev.H 17.06.12 As per Dwg. Rev.F DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4672-3

Manufactured

No

100

Each

18.0000

2

2

D4672-3

Blanking Plate

** 157868 x2 D.M.L 2017-07-31

Location

Loc Qty

Loc Code

WA004

18

157868

18

M304EX0.75-16F

Purchased

No

100

sf

458.5000

19.1516

19.1516

M304FX0 75-16F

Expanded Metal Flat SS

**

D.M.L 2017-8-3

Location

Loc Qty

Loc Code

WA004

458.5

M137294

11.5

M137765

447

138128

20

Picklist Print

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Work Order ID: 164020

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

150

Each

2,526.000

2

2

NAS1149FN832P

Washer

**

Location

Loc Qty

Loc Code

GA

358

M135058

208

M136182

40

M136866

110

ST260a

1500

M137820

1500

ST263

668

M137412

668

D4017-1

Manufactured

No

100

Each

3.0000

1

1

D4017-1

Rib

**148052 x1 D.M.L 2017-07-31

Location

Loc Qty

Loc Code

WA004

3

148052

3

D4017-3

Manufactured

No

100

Each

5.0000

1

1

D4017-3

Rib

**160505 x1 D.M.L 2017-07-31

Location

Loc Qty

Loc Code

WA004

5

160505

5

D4017-5

Manufactured

No

100

Each

1.0000

1

1

D4017-5

Hinge Rib

**157843 x1 D.M.L 2017-07-31

Location

Loc Qty

Loc Code

WA004

1

157843

1

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 164020

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-7

Manufactured No

100 Each

20.0000

3 3

D4017-7

Rib

**** 161932 x3 D.M.L 2017-07-31**

Location

Loc Qty

Loc Code

WA004

20

161932

10

161934

10

✓ D4017-9

Manufactured No

100 Each

2.0000

2 2

D4017-9

Rib

**** 164054 x2 D.M.L 2017-07-31**

Location

Loc Qty

Loc Code

WA004

2

161509

2

✓ D3916-041

Manufactured No

100 Each

4.0000

2 2

D3916-041

Rib Assembly

**** 163897 x2 D.M.L 2017-07-31**

Location

Loc Qty

Loc Code

WA004

4

157519

4

✓ D3916-5

Manufactured No

100 Each

4.0000

1 1

D3916-5

Light Rib

**** 163459 x1 D.M.L 2017-07-31**

Location

Loc Qty

Loc Code

WA004

4

163114

1

163458

3

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Shop Packet Print

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Work Order ID: 164020

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-041

Manufactured No

100 Each

5.0000

1 1

D4034-041

Aft Upper Rib Assembly

** ~~164023~~ x 1 D.M.L 2017-8-
163894 x 1
163948

Location

Loc Qty

Loc Code

WA004

5

163305

5

✓ D4034-043

Manufactured No

100 Each

6.0000

1 1

D4034-043

Fwd Upper Rib Assembly

** 163293 x 1 D.M.L 2017-07-31

Location

Loc Qty

Loc Code

WA004

6

163293

6

✓ D2581

Manufactured No

100 Each

58.0000

2 2

D2581

Mounting Bracket

** 162923 x 2 D.M.L 2017-07-31
162743 x 2 D.M.L 2017-8-9

Location

Loc Qty

Loc Code

WA004

58

161800

18

162923

40

✓ D3913-15

Manufactured No

100 Each

31.0000

1 1

D3913-15

Wide Handle Plate

** 161938 x 1 D.M.L 2017-07-31

Location

Loc Qty

Loc Code

WA004

31

161938

31

Picklist Print

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100 Each

70.0000 3 3

D4016-1

Hinge Half, Base

**** 159537 x3 D.M.L 2017 07-31**

Location

Loc Qty

Loc Code

WA004

70

158630

3

159537

67

D4020-11

Manufactured No

100 Each

5.0000 2 2

D4020-11

End Mesh, Basket

**** 16 B 164375**

Location

Loc Qty

Loc Code

WA006

5

162864

5

D2931

Manufactured No

150 Each

1,278.000 2 2

D2931

Bumper

Location

Loc Qty

Loc Code

ST013

178

86435

178

ST025A

1100

86435

1100

D4021-1

Manufactured No

100 Each

40.0000 3 3

D4021-1

Handle Plate

**** 164257 x2 D.M.L 2017 07-31**

161900 x3

Location

Loc Qty

Loc Code

WA004

40

161473

13

161900

27

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

11.0000

2 2

D4021-5

Blanking Plate

****B163685^2**

AUG 17 2017 *W*

Location

Loc Qty

Loc Code

ST068

11

161816

11

AN3-10A Purchased No

150 Each

86.0000

6 6

AN3-10A

Bolt

Location

Loc Qty

Loc Code

GA

39

m136787

39

ST349

47

m137321

4

m137544

43

M138084 6

AUG 17 2017 *W*

MS20600-AD4W3 Purchased No

150 Each

416.0000

2 2

MS20600-AD4W3

Cherry Rivet

Location

Loc Qty

Loc Code

ST308

84

m135603

84

WA003

332

m136648

32

m137412

300

2

AUG 17 2017 *W*

Picklist Print

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

150 Each 1,268.000 6 6

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136665

292

ST303

795

m137680

295

m137886

500

AUG 17 2017

NAS1149F0332P Purchased No

150 Each 2,142.000 12 12

NAS1149F0332P

**

Washer

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

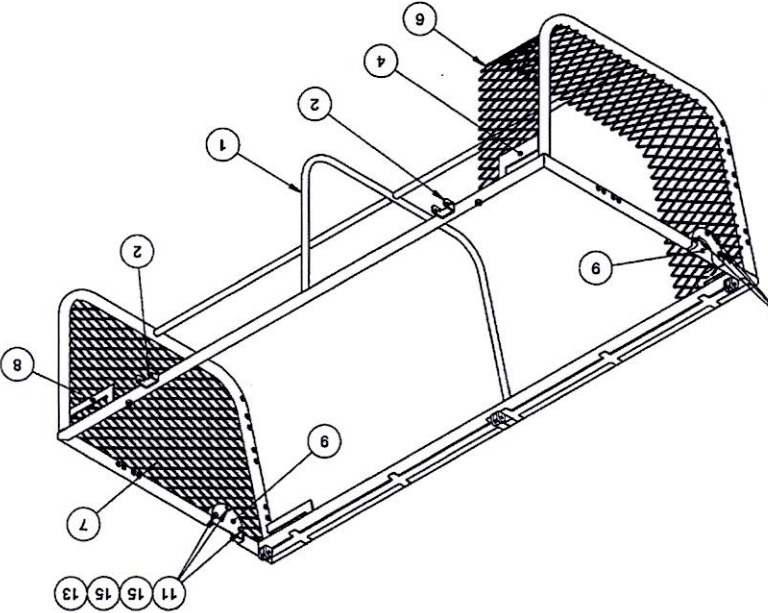
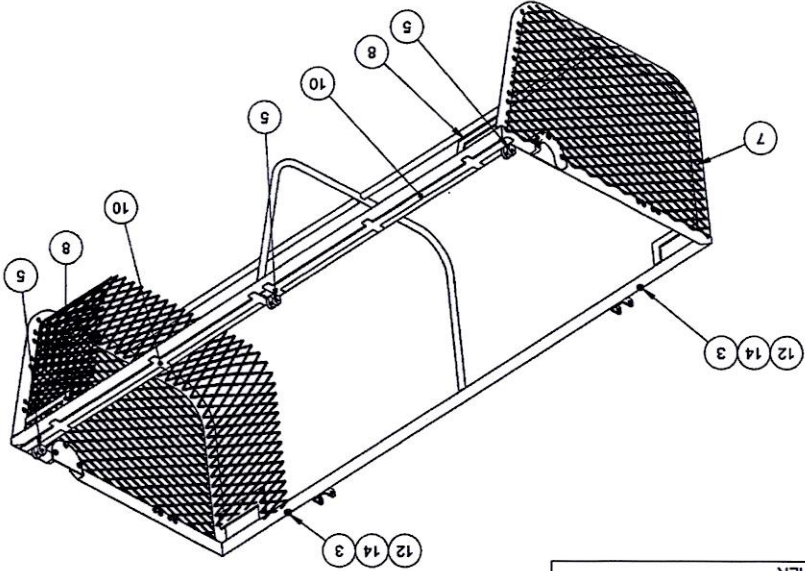
1867

m137710

1867

AUG 17 2017

ITEM	QTY	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
 - 7) WEIGHT: 30.0 lbs APPROX
 - 8) INSTALL AFTER FINISH
 - 9) MASK HOLES PRIOR TO POWDER COAT
 - 10) WELD PER DART QSI 004
 - 11) MASK THIS AREA PRIOR TO FINISH

10 044 6.4 PER QSI

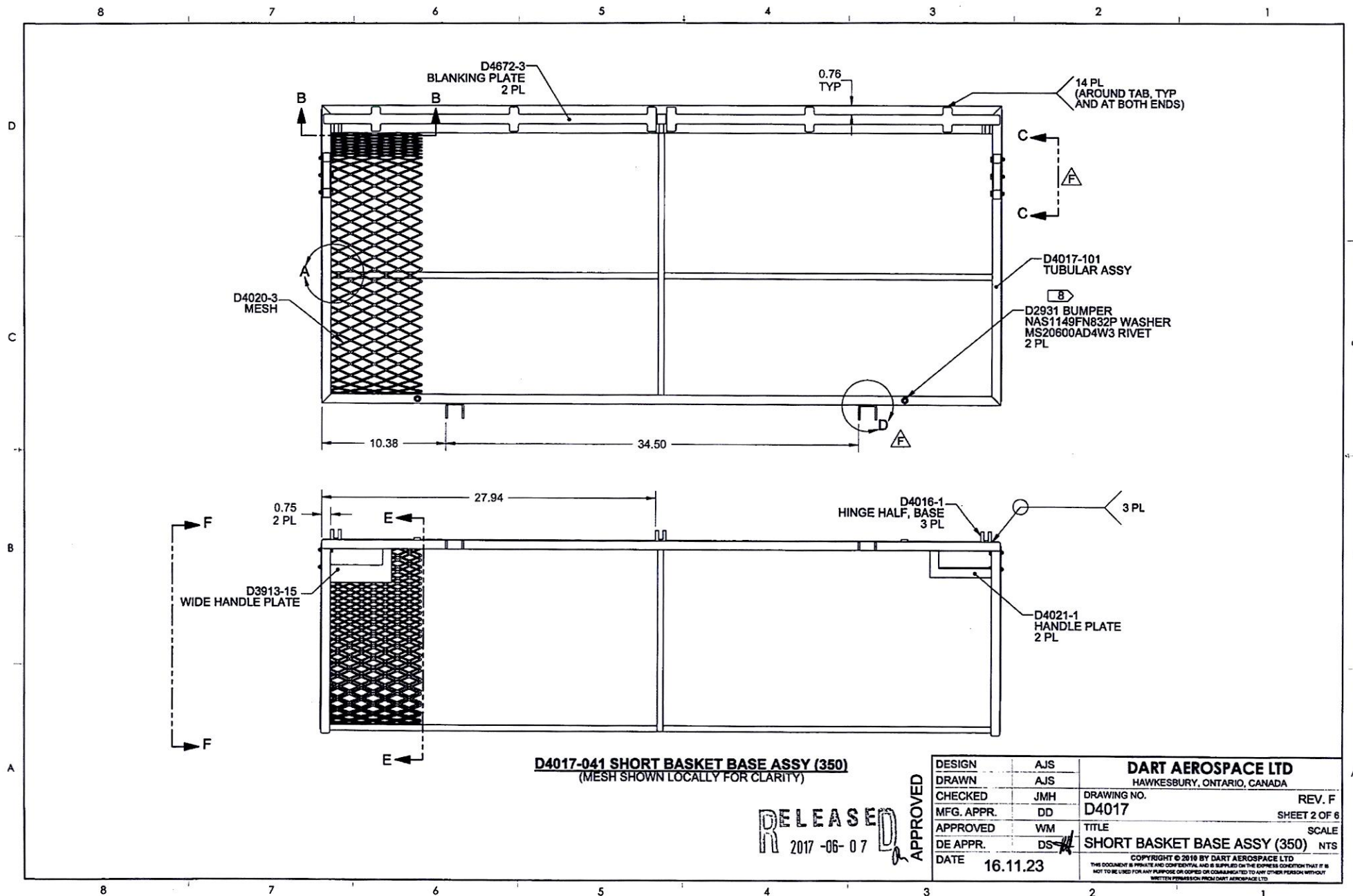
17-580
2017-06-07
E.C.A.S.T.D.

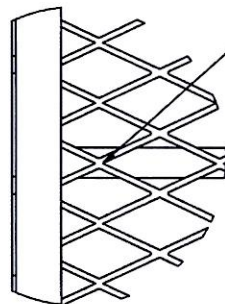
APPROVED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	10.03.04
B	RENUMBERED, DETAIL D UPDATED (A4-3) BOLT WAS AN3-10A, WAS1149F0332P WASHER WAS QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15, AN3-10A	JPH	10.03.25
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
D	ADD D4672-3 (2N C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PART 12-197.	MB	12.06.16
E	PICTORIAL UPDATE TO MULTIPLE VIEWS FOR CHANGES TO D4034-043, A4-4 28.13 DIM IS NOW REF.	AJS	13.07.16
F	ALL DETAIL/SECTION VIEW LETTERS UPDATED, SHEET WAS DETAIL D, SHEET 4; ADDED VIEW G-G. (PART 15-418)	AJS	16.11.23

DESIGN	DRAWN	CHECKED	APPROVED	DE APPR.	DATE
AJS	AJS	JMH	DD	DS	16.11.23
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWING NO. D4017					
TITLE SHORT BASKET BASE ASSY (350) NTS					
SCALE					
SHEET 1 OF 6					
REV. F					

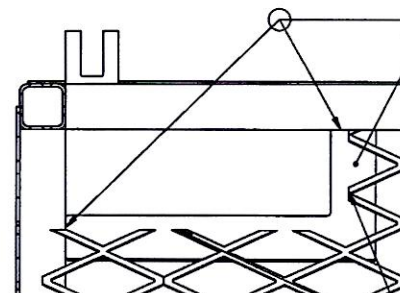
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

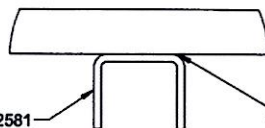
DETAIL A
SCALE 2X



D4021-1
HANDLE PLATE

SECTION B-B
TYPICAL FOR ALL
HANDLE PLATES

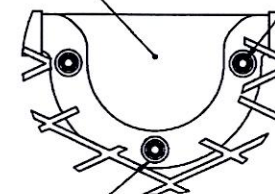
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



D2581
MOUNTING BRACKET

DETAIL D 
2 PL

 D4021-5
BLANKING PLATE



 AN3-10A BOLT
NAS1149F0332P WASHER, QTY (2)
MS21042L3 NUT
3 PL

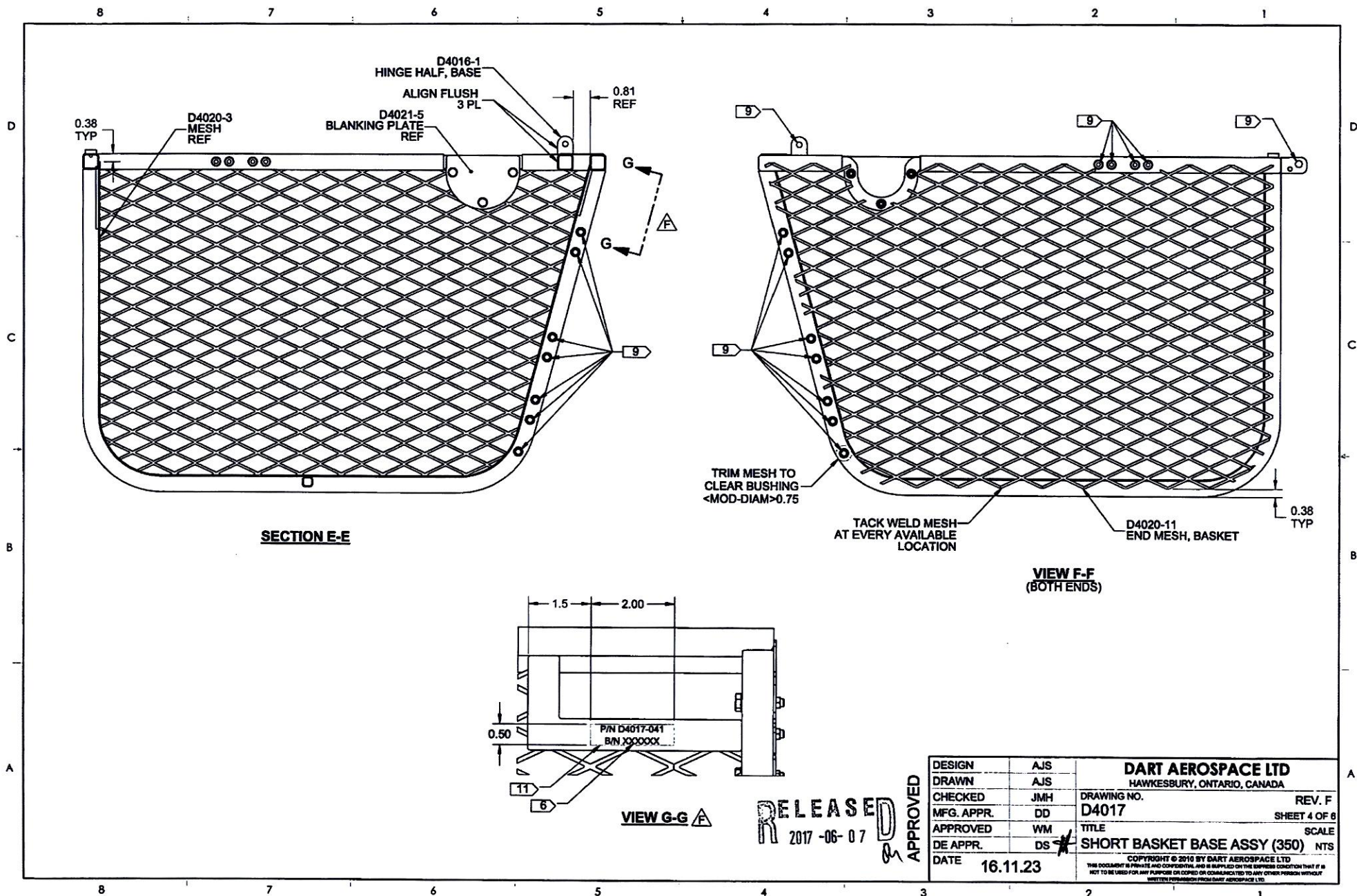
TRIM MESH LOCALLY
0.50 - 0.60
TO CLEAR FASTENERS

VIEW C-C
2 PL

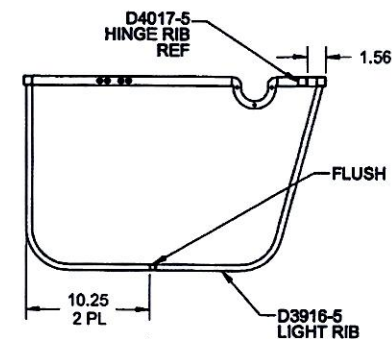
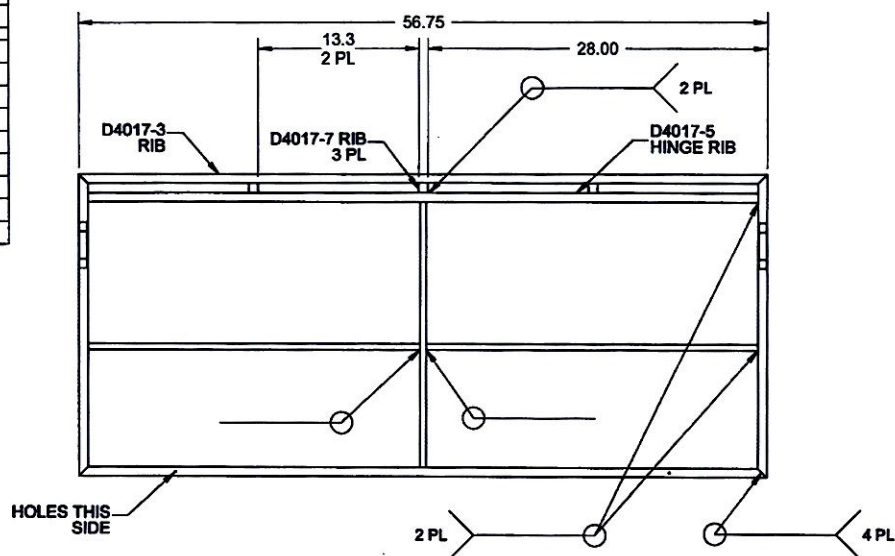
RELEASED
2017-06-07

APPROVED

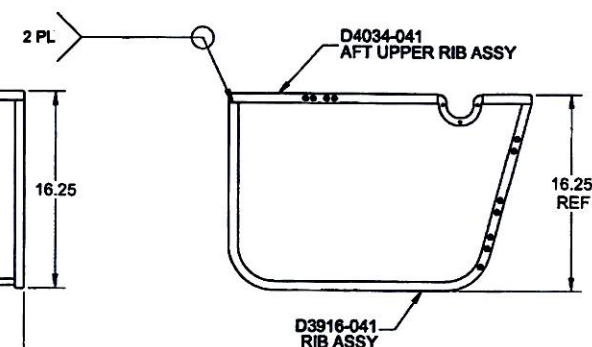
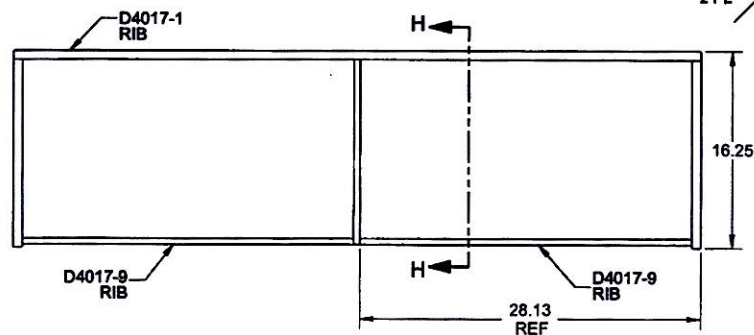
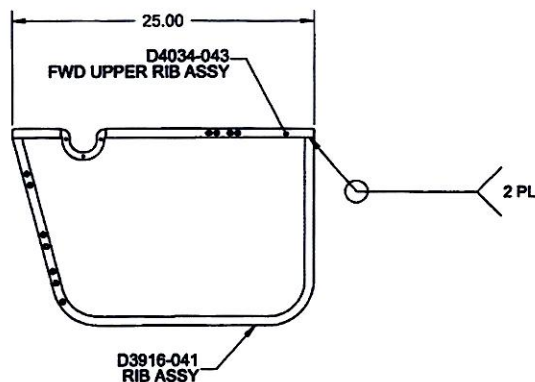

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. F
MFG. APPR.	DD	D4017	SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET BASE ASSY (350)	NTS
DATE	16.11.23	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	3	D4017-7	RIB
5	2	D4017-9	RIB
6	1	D3916-5	LIGHT RIB
7	2	D3916-041	RIB ASSY
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION H-H



8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

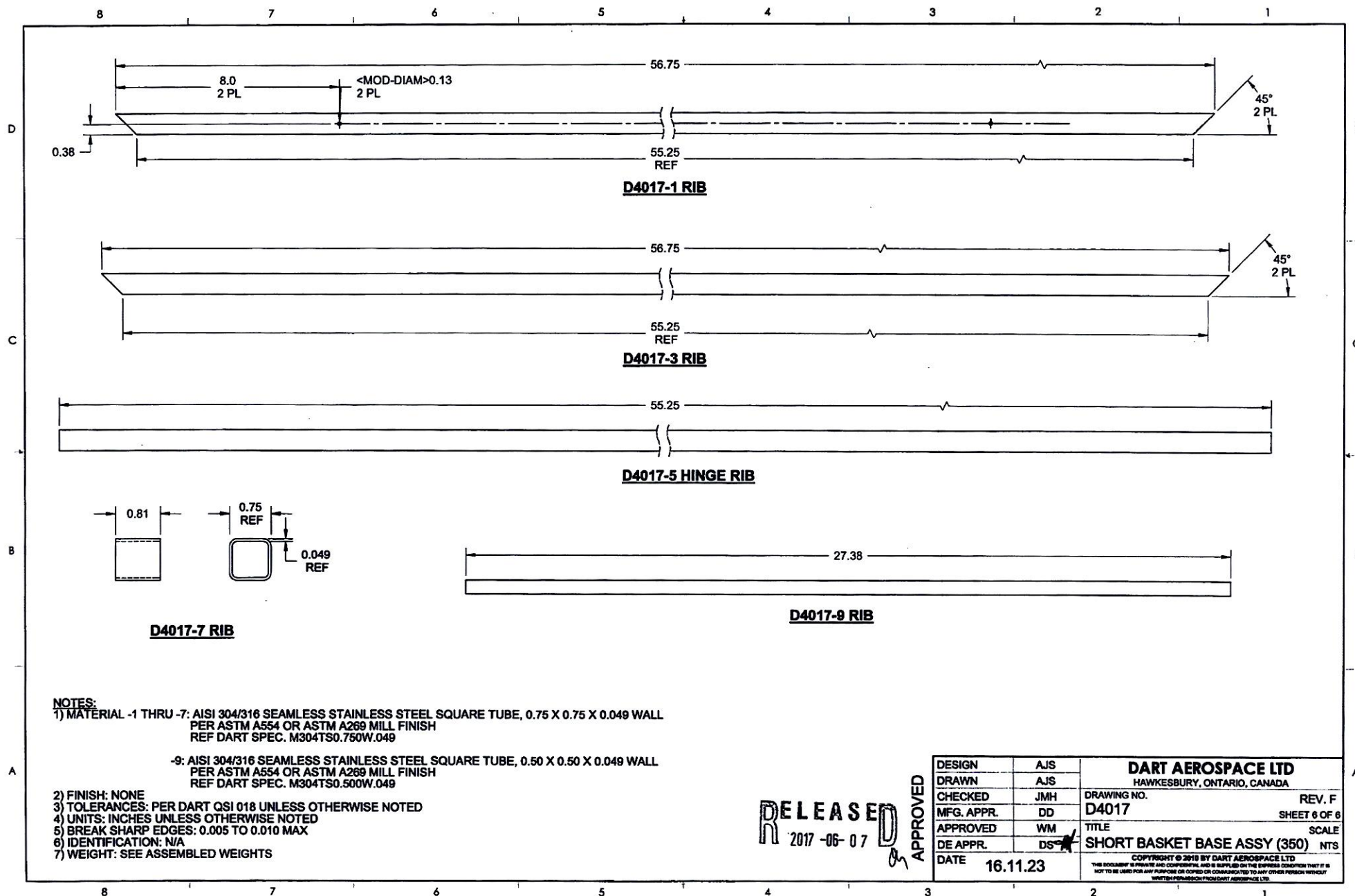
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.38 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

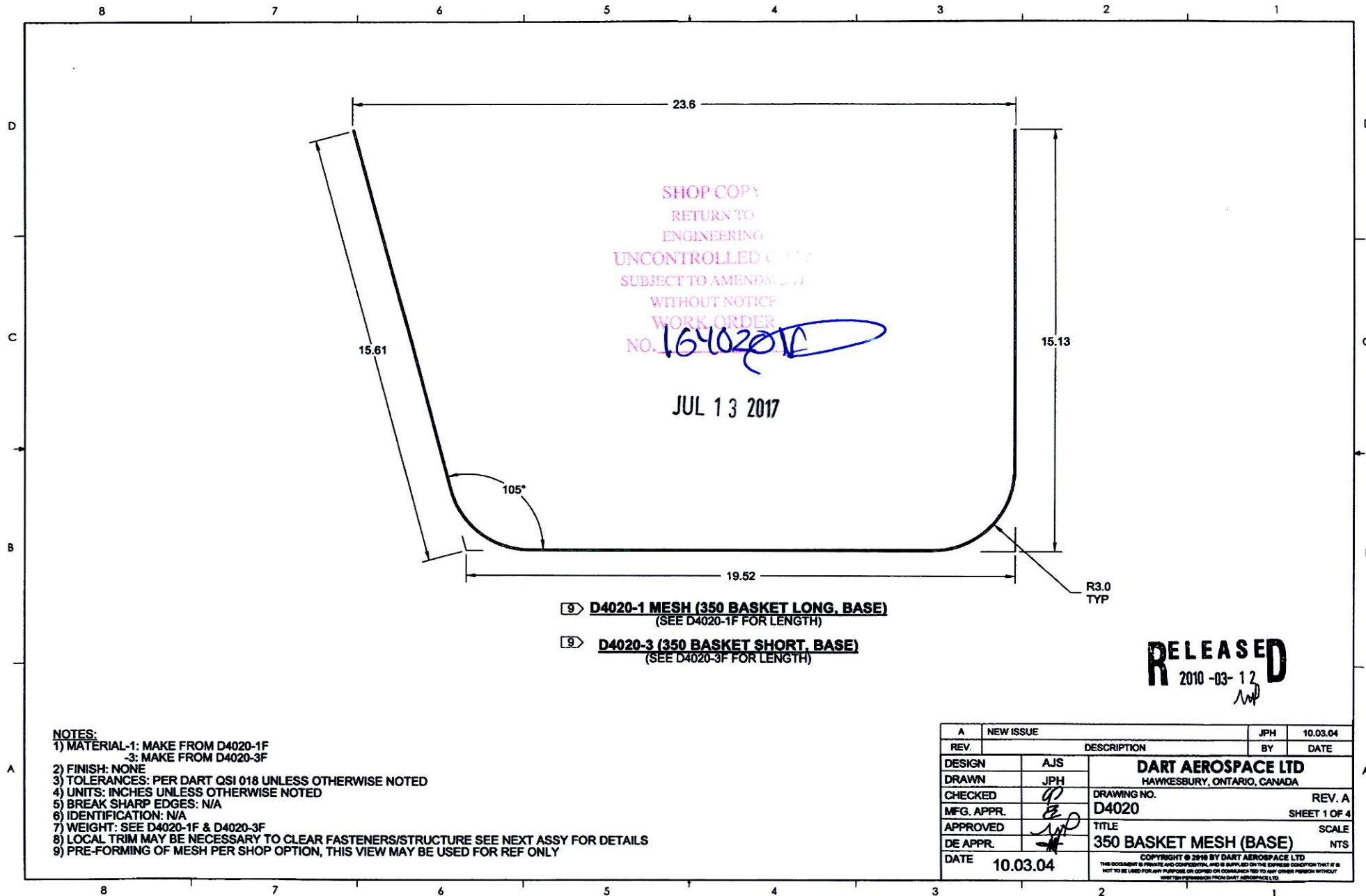
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2017-06-07

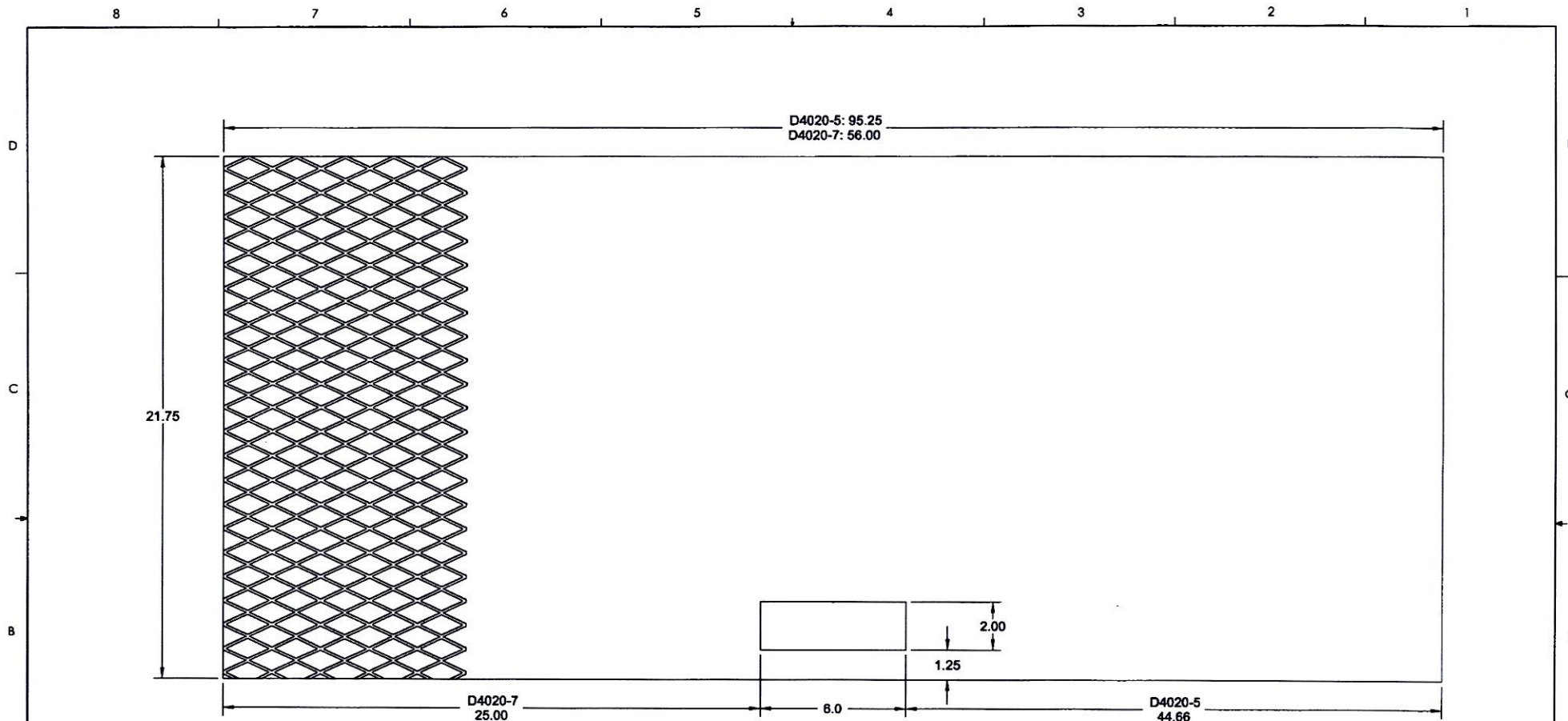
APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.23

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4017	REV. F SHEET 5 OF 6
TITLE SHORT BASKET BASE ASSY (350)	SCALE NTS
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9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

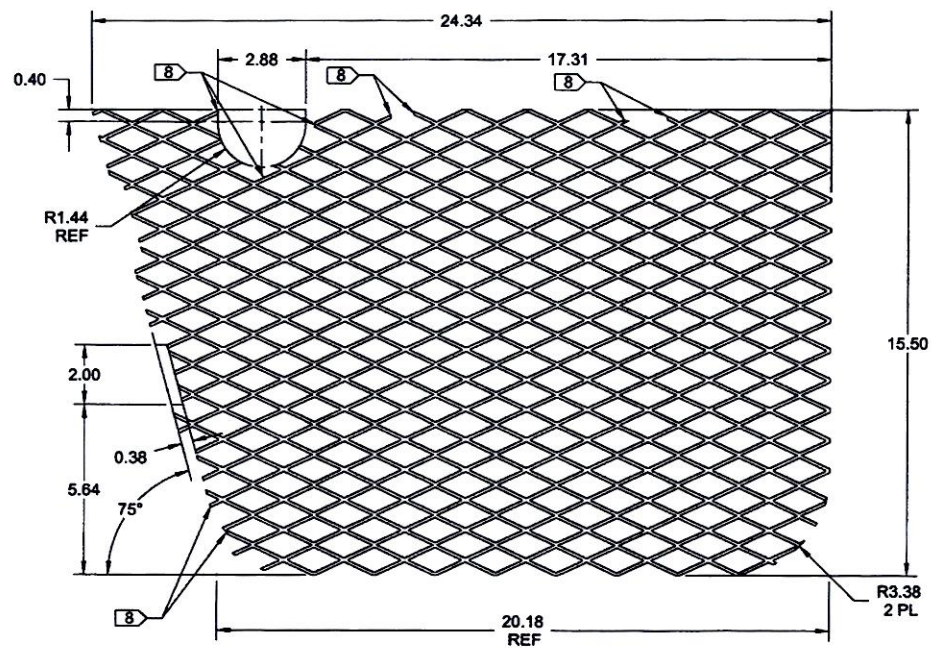
9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-12
MD

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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9) **D4020-11 END MESH, BASKET**

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	[Signature]	DRAWING NO. D4020	REV. A
MFG. APPR.	[Signature]	TITLE	SHEET 3 OF 4
APPROVED	[Signature]	SCALE	
DE APPR.	[Signature]	350 BASKET MESH (BASE)	
DATE	10.03.04	NTS	

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